

Date: Friday, 10/5/2007 11:02:15 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : PANEL
 Job Number : 35047
 Estimate Number : 10873
 P.O. Number : *N/A*
 This Issue : 10/5/2007 S.O. No. : *N/A*
 Prsht Rev. : NC
 First Issue : *N/A* Type : PURCHASED PARTS
 Previous Run : 34607
 Part Number : D32455
 Drawing Number : D3245 UNDER REVIEW
 Project Number : N/A
 Drawing Revision : A
 Material : *N/A*
 Due Date : 10/19/2007 Qty: 8 Um: Each
 Written By :
 Checked & Approved By : *07.10.05*
 Comment : Est. A 04.07.07 New issue KJ/JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M304S22GA 304/316 .032 Sheet



8.4420



Comment: Qty.: 0.8442 sf(s)/Unit Total : 6.7536 sf(s)

304/316 .032 Sheet

Batch: *M105262* *B07-10-18*

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3245

Dwg Rev: *A* *B07-10-18*

Prog Rev: *A*

2-Deburr if necessary *B07-10-18*

(10)

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



B07-10-18



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

Er 07/10/19 *(10)* *counter*

5.0 BRAKE NC NC BRAKE



Comment: NC BRAKE

Deburr if necessary

Form D3245-5 as per Dwg D3245 Identify as D3245-5

SB 07/10/20

(10)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: PD Date: 01/11/20
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 10/5/2007 11:02:15 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PANEL

Job Number: 35047

Part Number: D32455

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

6 07/11/20 (X10)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 79

JS 07/11/20 (10X) /

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

(K) 07/11/20

Job Completion



u 07-11-20

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



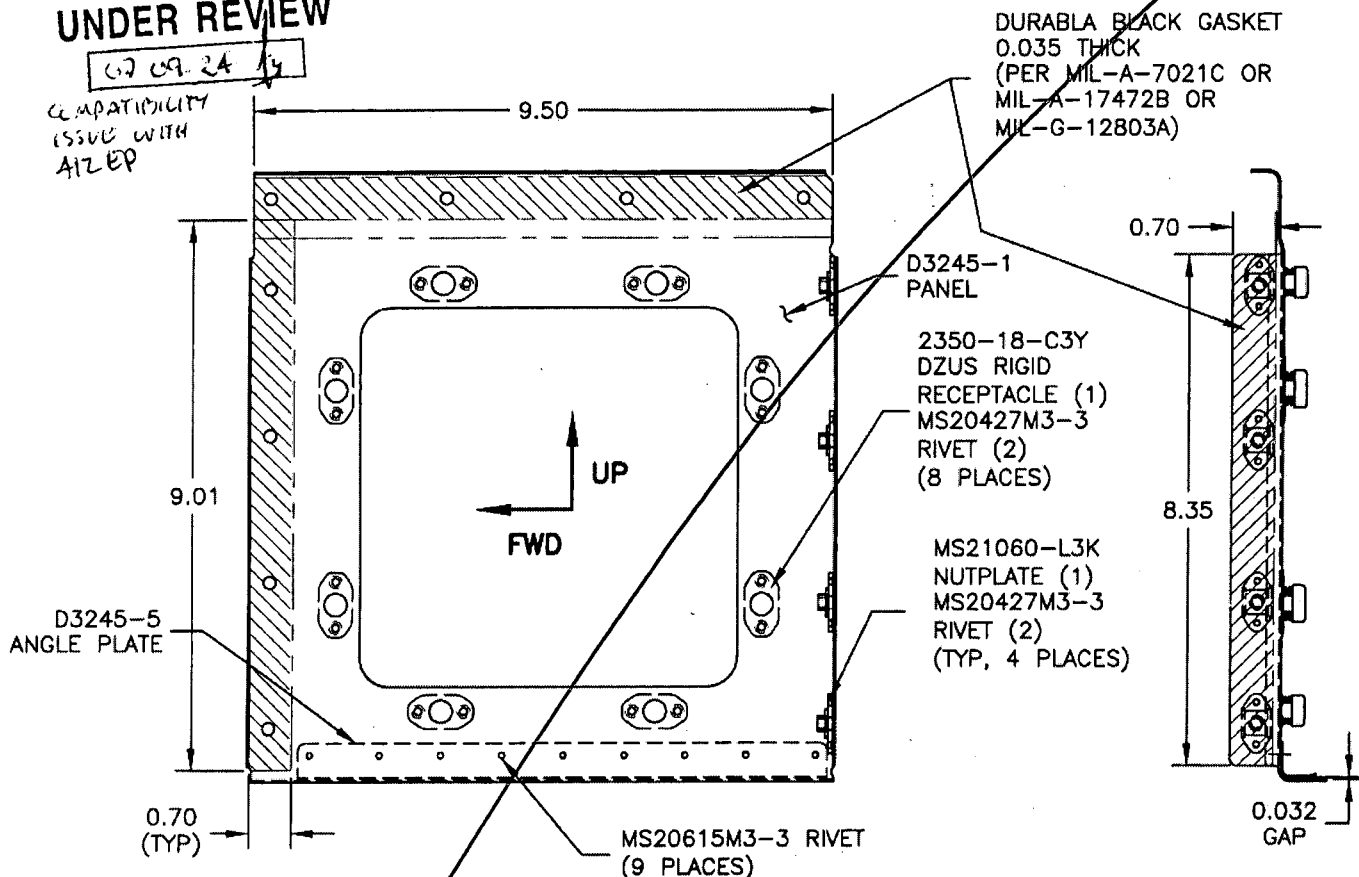
DESIGN	RF	DRAWN BY	CP	DART AEROSPACE LTD
				HAWKESBURY, ONTARIO, CANADA
CHECKED	AF	APPROVED	AF	DRAWING NO. D3245
				REV. A
DATE	04.01.27	TITLE	ACCESS PANEL ASSEMBLY	SHEET 1 OF 6
				SCALE 1:3
A	04.01.27	NEW ISSUE		

RELEASED
04.04.21

UNDER REVIEW

07.09.24

COMPATIBILITY
ISSUE WITH
A1Z EP



D3245-041 ACCESS PANEL ASSEMBLY

D3245-041 NOTES:

- 1) FINISH: NONE
- 2) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) INSTALL GASKET USING 3M SCOTCH-GRIP P/N 1300/1300L ADHESIVE IN ACCORDANCE WITH MANUFACTURER'S INSTRUCTIONS
- 5) ASSEMBLE IN ACCORDANCE WITH DART QSI 002
- 6) IDENTIFY WITH P/N & B/N USING FINE POINT PERMANENT MARKER

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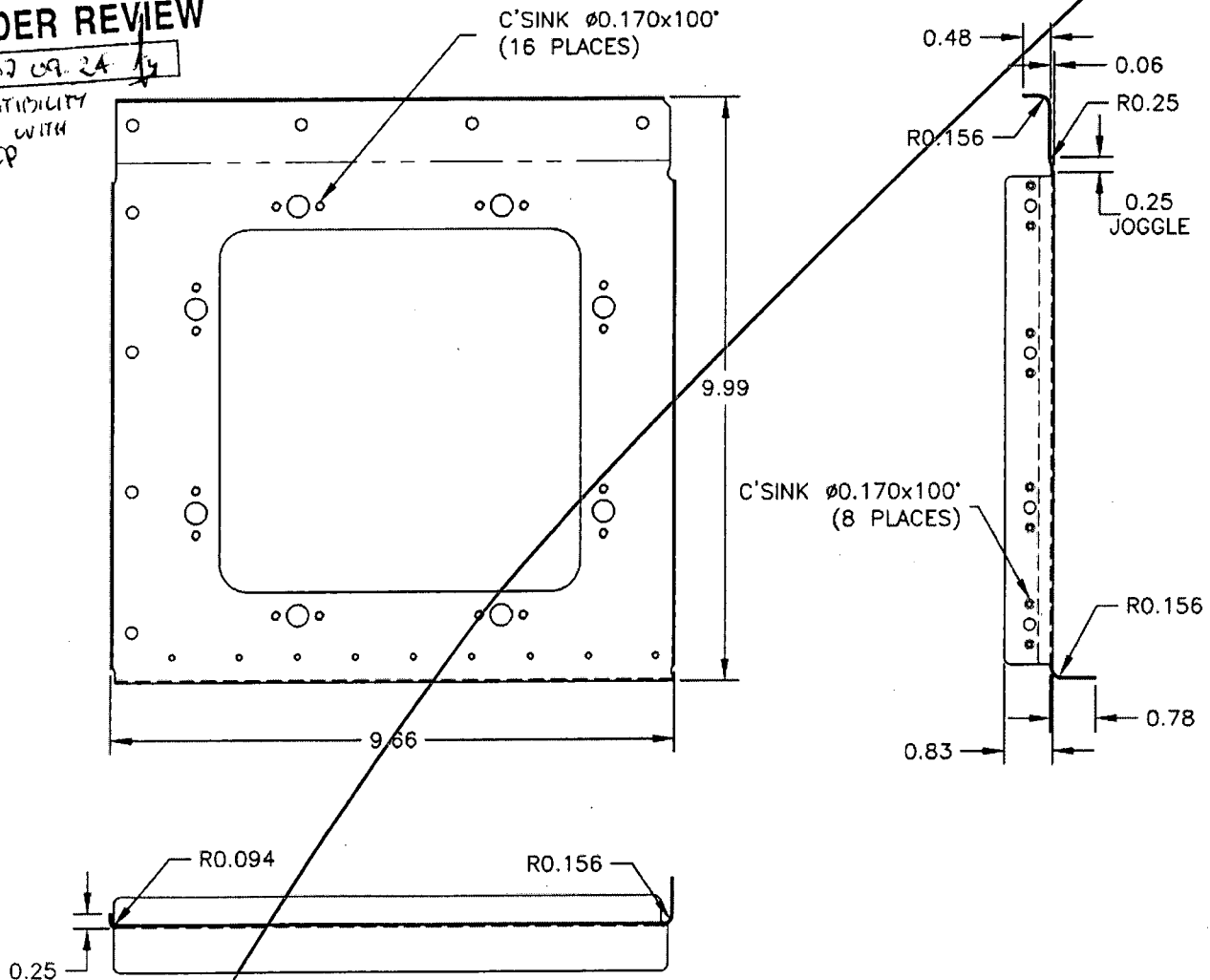
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				HAWKESBURY, ONTARIO, CANADA	
CHECKED	AF	APPROVED	AF	DRAWING NO. D3245	SHEET 3 OF 6
DATE	04.01.27	TITLE	ACCESS PANEL ASSEMBLY	SCALE	1:3

RELEASED
04.04.21

UNDER REVIEW

02.09.24

COMPATIBILITY
ISSUE WITH
A12 EP



D3245-1 PANEL BEND DETAIL SHOWN
BEND D3245-2 PANEL OPPOSITE

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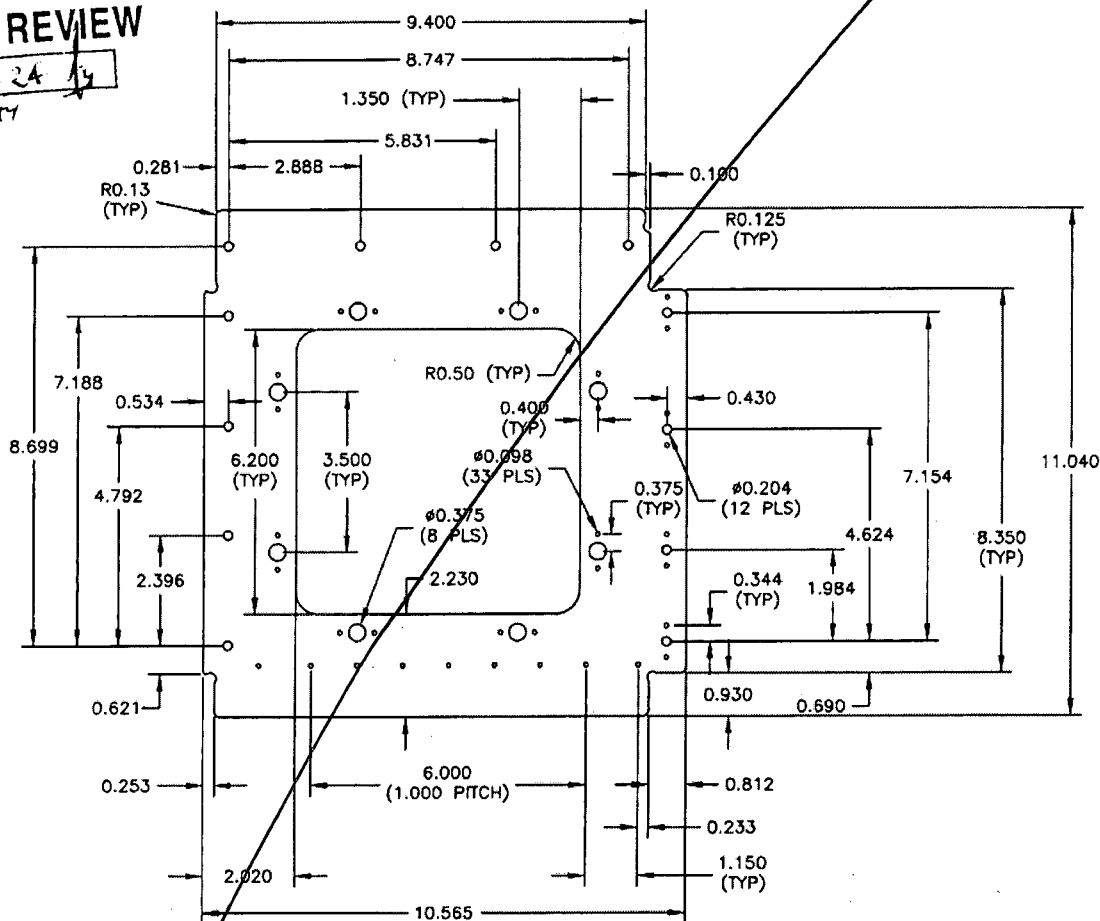


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CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3245	REV. A SHEET 4 OF 6
DATE 04.01.27	TITLE ACCESS PANEL ASSEMBLY		SCALE 1:4

RELEASED
04.04.21

UNDER REVIEW

COMPATIBILITY
ISSUE WITH
A12EP



D3245-1/-2 PANEL FLAT PATTERN

NOTES:

- 1) MATERIAL: AISI 304/316 SS 0.032 THICK (REF. M304S22GA)
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3245	REV. A SHEET 5 OF 6
DATE 04.01.27	TITLE ACCESS PANEL ASSEMBLY		SCALE 1:4

RELEASED
04.04.21

UNDER REVIEW
07.09.24

COMPATIBILITY
ISSUE WITH
AIZ EP

D3245-7 GASKET (REF)

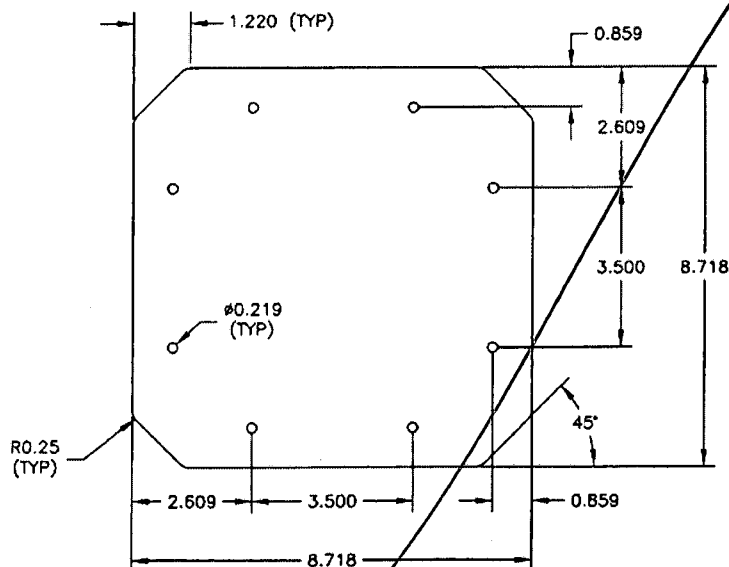
D3245-5 DOOR

2351-20-009-C3Y STUD (1)
127H-35 GROMMET (1)
(8 PLACES)

0.42
R0.094

INSTALL D3245-7
GASKET ON THIS SIDE

D3245-043 DOOR ASSEMBLY

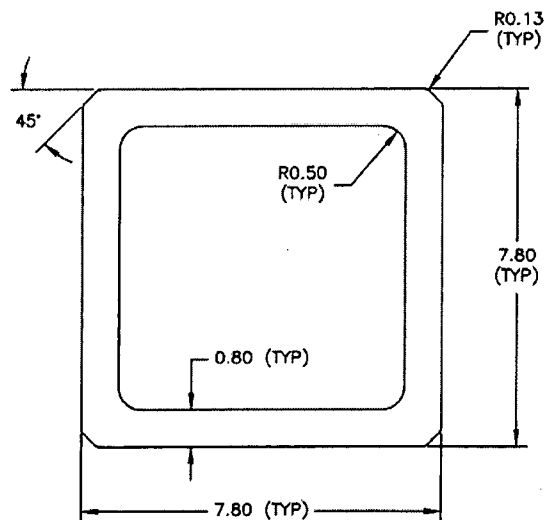


D3245-3 DOOR FLAT PATTERN

MATERIAL: AISI 304/316 SS 0.032 THICK
ANNEALED (REF. M304S22GA)

D3245-043 NOTES:

- 1) FINISH: NONE
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) INSTALL D3245-7 GASKET USING 3M SCOTCH-GRIP 1300/1300L ADHESIVE
IN ACCORDANCE WITH THE MANUFACTURER'S INSTRUCTIONS
- 6) ASSEMBLE IN ACCORDANCE WITH DART QSI 002
- 7) IDENTIFY WITH P/N & B/N USING FINE POINT PERMANENT MARKER



D3245-7 GASKET

MATERIAL: DURABLE BLACK GASKET 0.035 THICK
(PER. MIL-A-7021C OR MIL-A-17472B
OR MIL-G-12803A)

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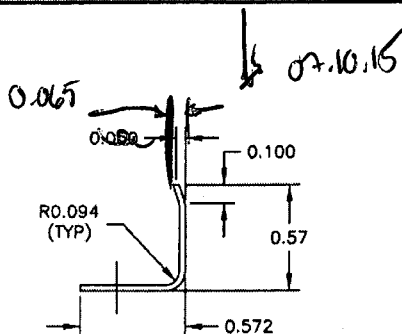


DESIGN H	DRAWN BY H	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D3245	REV. A SHEET 6 OF 6
DATE 04.01.27		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:4

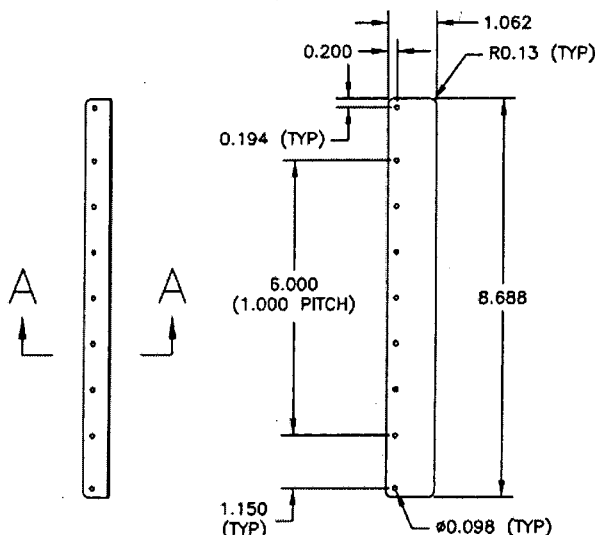
RELEASED
04.04.05

UNDER REVIEW

COMPATIBILITY
ISSUE WITH
A12EP



D3245-5 BEND DETAIL
VIEW A-A
SCALE 1:1



D3245-5 FLAT PATTERN

D3245-5 NOTES:

- 1) MATERIAL: AISI 304/316 SS 0.032 THICK ANNEALED (REF. M304S22GA)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

OK PBL REV. A
07.10.15

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